

Work Order ID 76746

76746

Page 1

Monday, November 21, 2011 10:18:48 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11/21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100
100 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 Memo 0.00 20 11.12-3 8 φ
 HAAS CNC vertical machine #1
 Program part number and batch number.
 Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB073
 FOLIO REV: AA
 DWG REV: E

110
110 CONVENTIONAL MILLING MACHINE 0.00
 Mill Conv Memo 0.00 20 11.12-3 8 φ
 Conventional Milling Machine
 Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

24 11.12.3

11/12/04

8x0 m-11/12/06

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

9:30
10:00
320°F

8XØ M-f 11/12/07

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

8 BK 11-12-7.

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

Memo

0.00

11/12/11 ⑧

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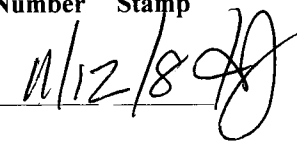
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/8 
MF
11-12-07

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Picklist Print

Monday, November 21, 2011 10:18:52 AM

Page 1

Work Order ID: 76746

76746

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			
D6101-003									**				
Saddle Billet, 7075													

26 11.12.3

Location	Loc Qty	Loc Code
MAT040	105	
72226✓	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
74680	26	

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DART AEROSPACE LTD	Work Order:	767416
Description: 206 Saddle, Outboard, Left side	Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No-Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	.130	.130	.130	.130	.130	.130	.130
B	0.100	0.140	.124	.124	.124	.124	.124	.124	.124
C	1.125	1.145	1.136	1.136	1.136	1.136	1.136	1.136	1.136
D	0.615	0.685	.670	.670	.670	.670	.670	.670	.670
E	0.240	0.260	.252	.252	.252	.252	.252	.252	.252
F	1.313	1.343	1.324	1.324	1.324	1.324	1.324	1.324	1.324
G	0.210	0.230	.222	.222	.222	.222	.222	.222	.222
H	0.100	0.180	.135	.135	.135	.135	.135	.135	.135
I	2.470	2.510	2.492	2.492	2.492	2.492	2.492	2.492	2.492
J	1.565	1.585	1.576	1.576	1.576	1.576	1.576	1.576	1.576
K	0.235	0.240	.237	.237	.237	.237	.237	.237	.237
L	0.100	0.120	.112	.112	.112	.112	.112	.112	.112
M	0.990	1.010	1.000	1.000	1.000	1.000	1.000	1.000	1.000
N	0.510	0.515	.512	.512	.512	.512	.512	.512	.512
O	5.990	6.010	6.002	6.002	6.002	6.002	6.002	6.002	6.002
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318	.313	.313	.313	.313	.313	.313	.313
S	0.315	0.322	.316	.316	.316	.316	.316	.316	.316
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	1.362	1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807	.797	.797	.797	.797	.797	.797	.797
W	0.540	0.560	.550	.550	.550	.550	.550	.550	.550
X	1.674	1.684	1.679	1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262	.257	.257	.257	.257	.257	.257	.257
Z	0.912	0.932	.918	.918	.918	.918	.918	.918	.918
AA	0.490	0.510	.496	.496	.496	.496	.496	.496	.496
AB	0.178	0.198	.188	.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

29.02
29.02

4

Measured by: <u>RF</u>
Date: <u>11-12-3</u>

Audited by: <u>B.A</u>
Date: <u>11/12/04</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

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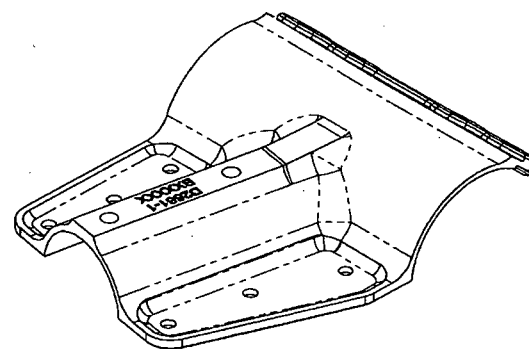
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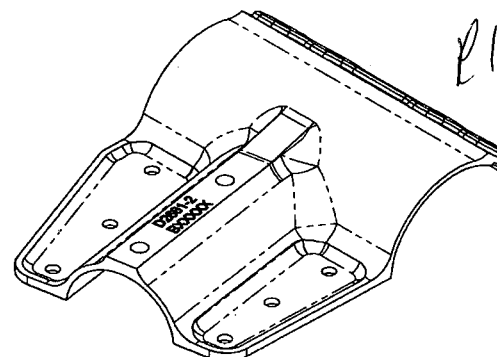
NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO VARIATION
 WITHOUT NOTICE
 WORK ORDER
 NO. 76746

211-11-21



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B8-4); REF NCR 11-835	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<div>DART AEROSPACE USA, INC.</div> <div>KENT, WA</div> <div>DRAWING NO. D2661</div> <div>TITLE SADDLE, OUTSIDE</div> <div>SCALE NTS</div> <div>SHEET 1 OF 5</div> <div>REV. E</div> <div>DATE 11.10.31</div> <div><small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small></div>	
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		

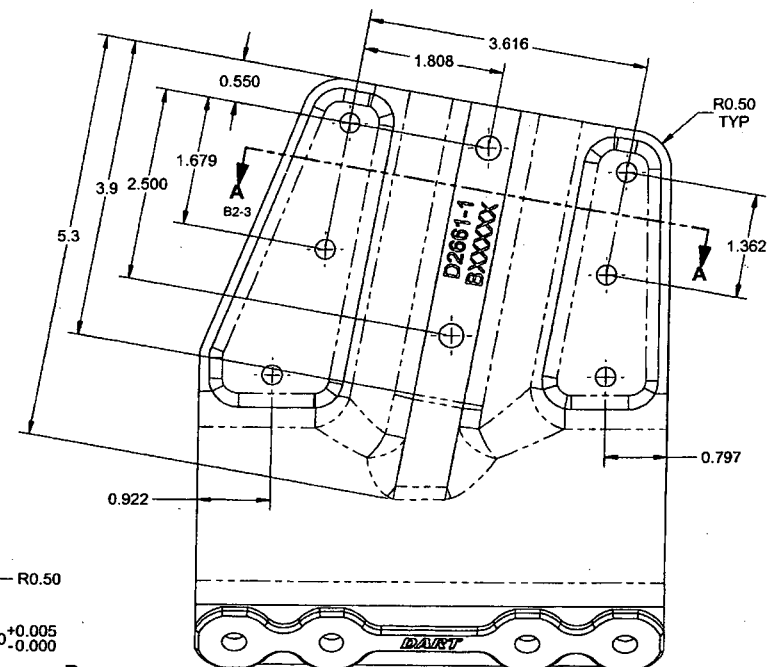
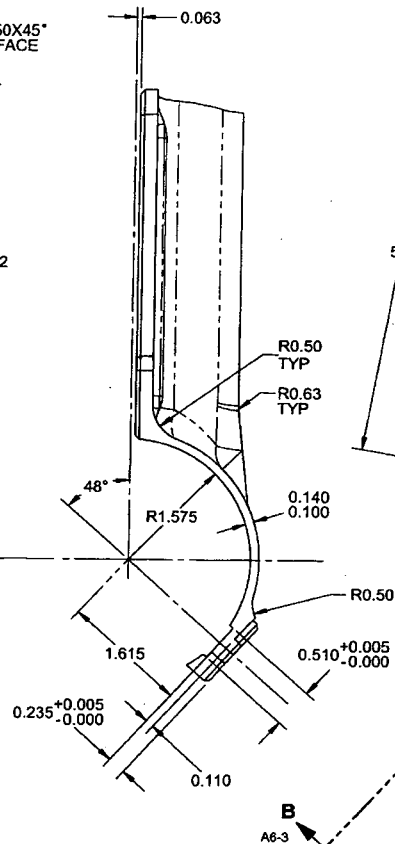
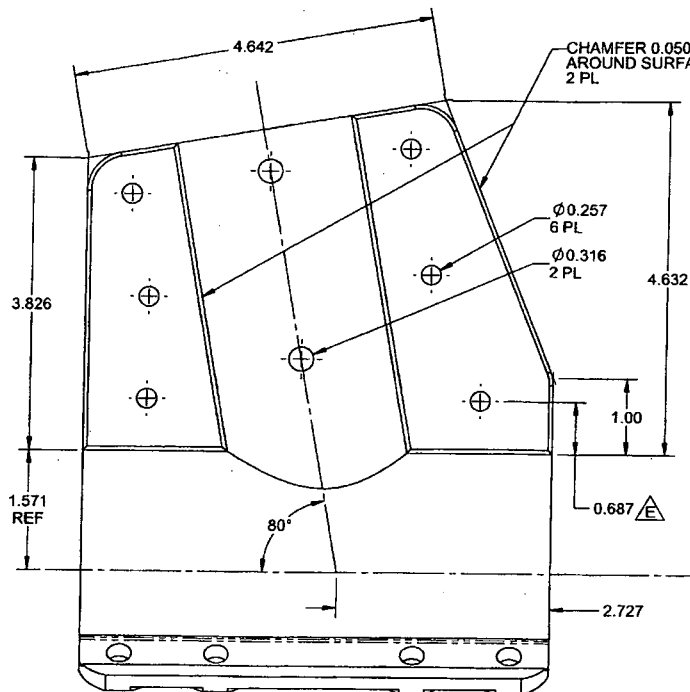
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D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING) USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010 IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING) USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN	JB	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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RELEASED
R 2011-11-16

76744

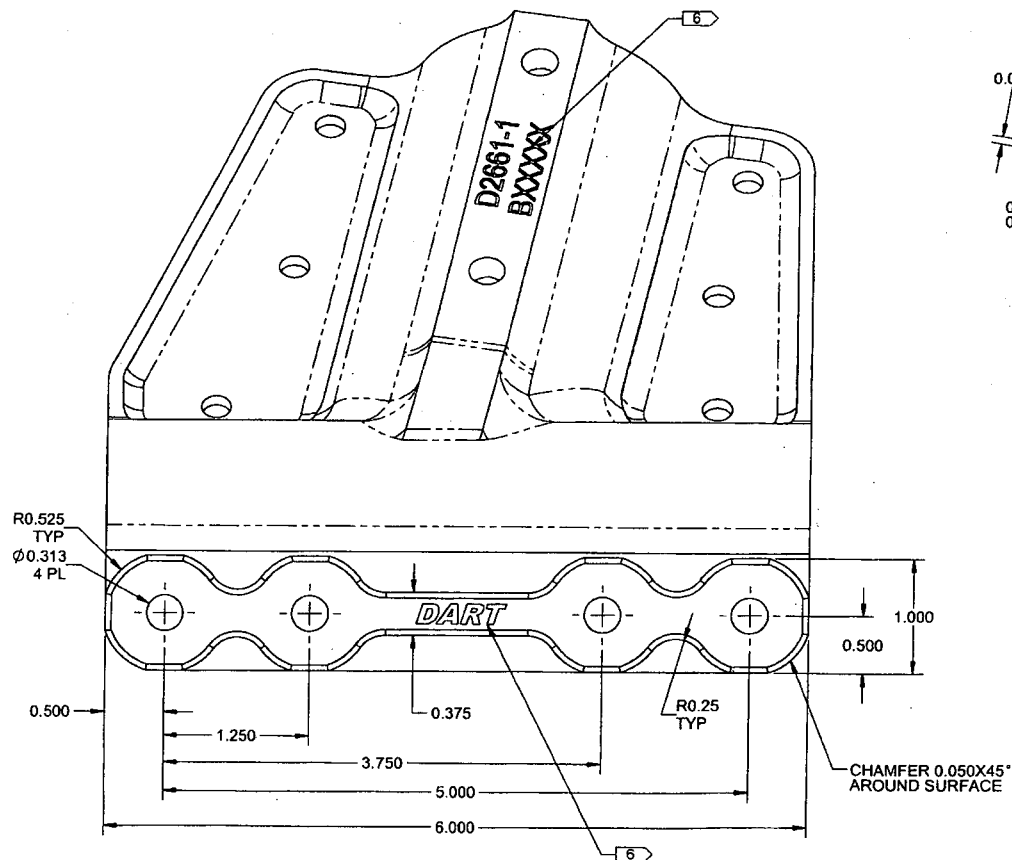
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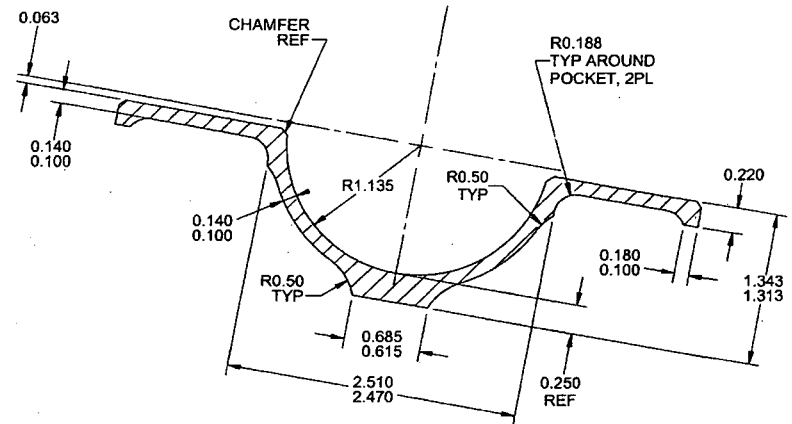
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VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

RELEASED
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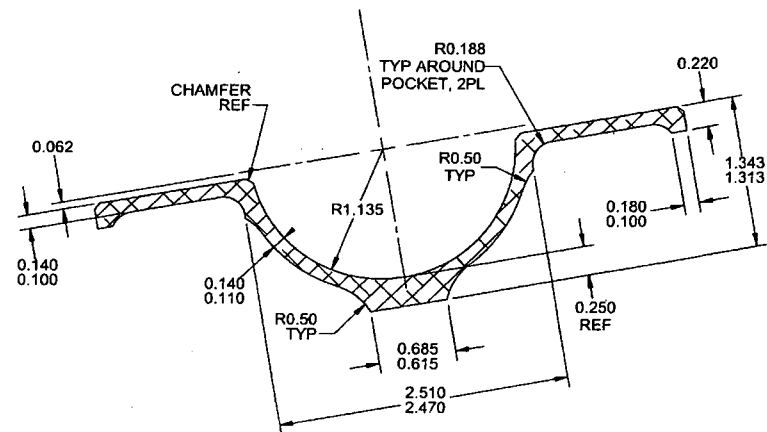
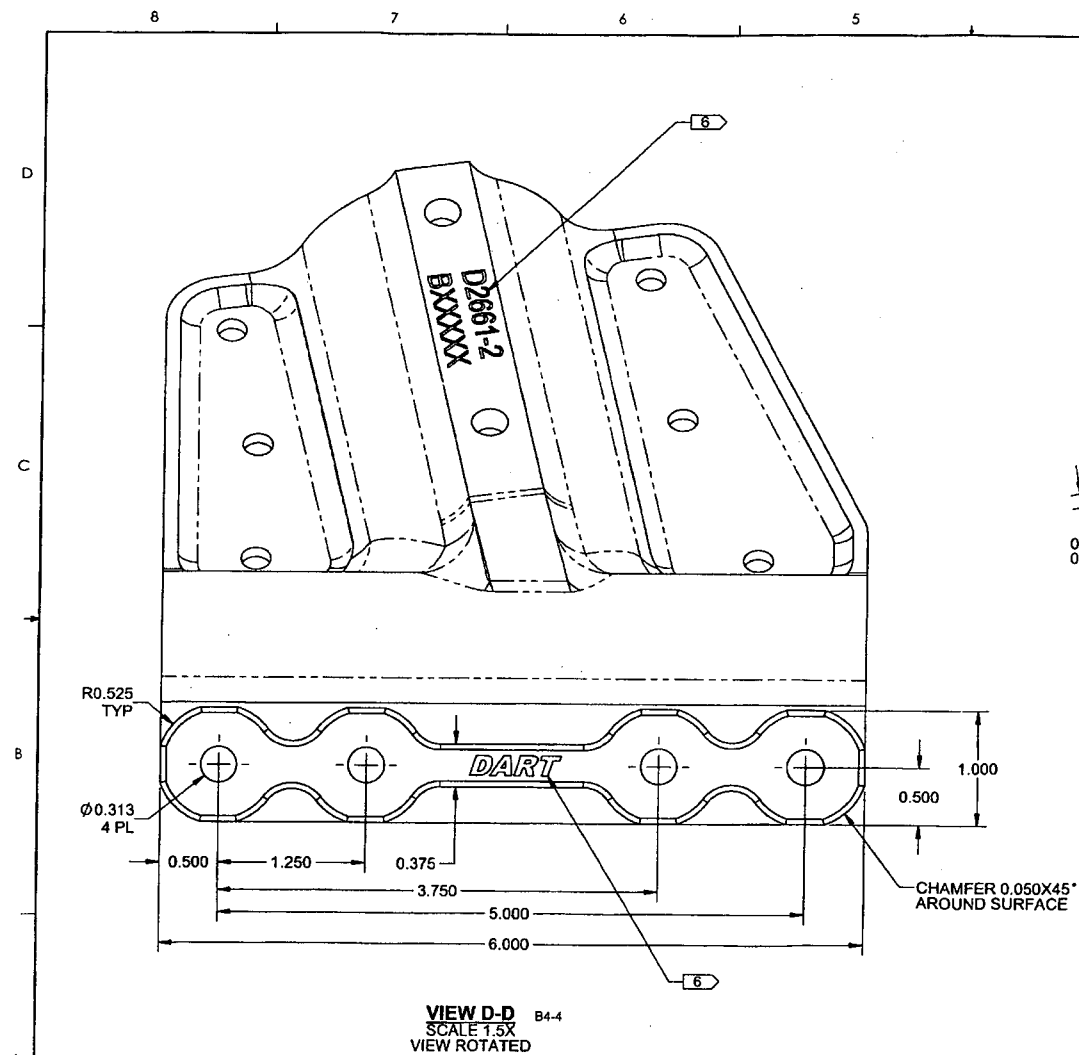
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